Work Ord June-12-13 9:2		8094		*103094*											
Item ID: Revision ID: Item Name: Start Date:	D3161-9" Hinge 17.0" 6/11/13	Start Qty: 8.00	*8*	Accept	*N900		100	)* s	Setup Star	I VI	S1* S2*				
Required Date Reference:	e: 6/11/13	Req'd Qty: 8.00	*8*		Customer:										
Approvals:	Process Plan	n:	Date://3-///_/_/	Tooling: SPC (Y/N):		ate:			Run Sta Sto	!/	R1* R2*				
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp				
Draw Nbr	Revi	ision Nbr													
D3161	Rev	A2													
*100 *100* Small Fab Small Fab		Small Fab  Memo (1) 72" His D3161	nge makes (4) D3161-9 parts	0.00 0.00 at 17" longCut to lengt	h as per Dwg			81			Szp				
110 *110* QC Quality Control		QC5- Inspect part com	pleteness to step on W/O	0.00 16 0.00 9-8	3101.4	#1 		(46)	)						
120 *120*		Identify as per dwg & S	Stock Location: <u>5703</u> 1	0.00				8			13-07-05				
Packaging Packaging		Memo		0.00							1001				

DQA: Date:				WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only		AEROSPACE	
Work Orde	ır.				DISPOSITION			AGAIN	IST DE	PARTMENT	/PROCESS			
WOIR Olde					Rework	1		Skid-tube Crosstu	ihe	7	Water Jet	T Fne	gineering	
Part N	lo.				Scrap			Machining Small	· -	Pro	d. Eng. Coor.	┤ ```	Quality	
				_	Use-as-is			noforming Finish		<b>⊣</b>	e/Packaging	1	Other	
NCR N	lo				Suspected Unapproved			Large Fab Compos	~ ⊢	]	Supplier			
Root	1			Desci	ription of work order update		nitial	Action		Sign &			<u>.</u>	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		C Inspector	
Design					,									
Doc/Data														
Equip/Tooling														
Handling/Pre		1										İ		
Material												ŀ		
Operator											ļ.			
Offset/Setup														
Process														
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Training														
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Unapproved		<u> </u>				L	• · · · · · · · · · · · · · · · · · · ·							
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Landir	ng Gear				General	_	1			7	-			
	Bending			<u> </u>	Bend		ł .	Program	<u> </u>	Outside Dim	}-		ure/Forced	
	<del></del> i	ot Conce	ntric		BOM/Route	┕	Grain			Over/Under	tolerance	Set-ເ	ıp	
	Cracks			$\vdash$	Broken/Damage/Defect	L	Hardwa			Part Incorred	ct	Temp	erature/Cure	
	Crimp/Ki	nk/Ripple	e/Wave		Burrs	L	Inspect	ion Incomplete/Unqualified	L	Part Lost/Mi		Weld		
	Cuffs			<u> </u>	Contamination		1	tions Incomplete/Unclear		Part Moved	Ĺ	Wror	ng Stock Pulled	
	Crushing			_	Countersink	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	i i	gned/off center		Positioned V		_		
	Heat Tre			$\perp$	Cut Too Short	_	Mislab		L	Power Loss/	Surge	Othe	r	
	Inspection		Tube	_	Drawing		Misrea							
	Marks/Cl				Drill Holes		Off-set							
	Turning S				Finish		Out of	Calibration						
1	Wave/Twist in Tube				Fit/Function	1	Out of	Seguence			<u></u>			

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Work Order ID 103094 \*103094\* Page 2 June-12-13 9:26:56 AM Item ID: D3161-9 Accept \*N900040100\* Setup Start **Revision ID:** Hinge 17.0" Item Name: Start Qty: 8.00 **Start Date:** 6/11/13 **Cust Item ID:** Required Date: 6/11/13 Req'd Qty: 8.00 **Customer:** Reference: Run Process Plan: Tooling: Approvals: Date: Date: Stop Date:\_\_\_\_\_ QC: SPC (Y/N): Date: Sequence ID/ Operation Tool # Plan Reject Set Up/ Tool ID Accept Reject Insp. Work Center ID Number Description **Run Hours** Code Qty Qty Stamp 130 QC21- Final Inspection - Work Order Release 0.00 \*130\* 0.00 Memo Quality Control

DQA: Date:			WORK ORDER MON											
QA Closed: Date:						WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only								
						DISPOSITION								
Work Orde	er: —		···- ··· ·		<del></del>	Rework	:	Skid-tube	Crosstube	٦	Water Jet	Engineering		
Part N	Nο					Scrap			Machining Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
· are r	···-					Use-as-is			noforming	Finishing	_	re/Packaging	Other	
NCR N	No					Suspected Unapproved			Large Fab	Composite		Supplier		
Root					Desc	ription of work order update		nitial	Actio	n	Sign &			
Cause		Date	Step	Qty	Desci	or non-conformance	l	ief Eng	1		Date	Verification	QC Inspector	
Design		· · · · · · · · · · · · · · · · · · ·						<u>,                                    </u>						
Doc/Data	П													
Equip/Tooling														
Handling/Pre			1									:		
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
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						·	FA	ULT CA	TEGORY		· ·			
Landi	ng Ge	ar				General		-				-	<del>-</del> 7	
	Шв	ending				Bend	乚	Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
	$\Box$ c	entre N	ot Concer	ntric		BOM/Route	匚	Grain		_	Over/Under	tolerance	Set-up	
		racks				Broken/Damage/Defect		Hardwa	are	<u></u>	Part Incorre	ct	Temperature/Cure	
		rimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Und	ualified	Part Lost/Mi	ssing	Weld	
Cuffs		Contamination		Instruct	tions Incomplete/Ur	nclear	Part Moved		Wrong Stock Pulled					
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	<b>-</b>	
		leat Trea	it			Cut Too Short	L	Mislabe	eled		Power Loss/	Surge	Other	
	∐"	nspectio	n Strip in	Tube		Drawing	L	Misrea	d					
		∕larks/Cl	atter			Drill Holes		Off-set						
	Шт	urning S	equence			Finish		Out of	Calibration					
	Wave/Twist in Tube			Fit/Function	Out of Sequence									

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**Picklist Print** 

June-12-13 9:26:56 AM

Work Order ID:

103094

Parent Item:

D3161-9

Parent Item Name:

Hinge 17.0"

**Start Date:** 6/11/13

Required Date: 6/11/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A04.08.24New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200 Piano Hinge		Purchased	No			100	f	70.3753	1.65	13.2	50	3/07	2/04
				<b>Location</b>		Loc Oty	<u>Lo</u>	c Code					
				ST209a		70.3752628							
				1239	60	6.4552628			<del></del>	· · · · ·			
				1254	45	63.92			نہ/_	1-2			

Page 1

DQA: Date:															
QA Closed: Date:						WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only									
						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS			
Work Orde	er: .				<del></del>	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	١٥.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
		•				Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other		
NCR N	۷o.					Suspected Unapproved			Large Fab	Composite		Supplier			
Root					Desci	ription of work order update	П	Initial	Act	tion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector		
Design															
Doc/Data													-		
Equip/Tooling											1				
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training Transport															
Unapproved	-	1													
опаррточео		<u> </u>	L	<u> </u>	l		EΔ	III T CA	TEGORY	<del></del>	<u> </u>		<u> </u>		
Landi	ne (	Gear				General	17	OLI CA	ILGONI				·		
		Bending				Bend	Г	Teolio/F	rogram	Γ	Outside Dim	ensions	Pressure/Forced		
:		Centre No	ot Concer	ntric		BOM/Route		Grain	106.4111	-	Over/Under	<del>}</del>	Set-up		
		Cracks				Broken/Damage/Defect	$\vdash$	Hardwa	ire	-	Part Incorre	<del>)</del>	Temperature/Cure		
	<u> </u>	Crimp/Kir	nk/Ripple	/Wave		Burrs	$\vdash$	4	ion Incomplete/U	ngualified	Part Lost/M	<u> </u>	Weld		
Cuffs		Contamination		1 '	ions Incomplete/	· · · · · · · · · · · · · · · · · · ·	Part Moved		Wrong Stock Pulled						
Crushing			Countersink	T	4	ned/off center		Positioned V							
Heat Treat			Cut Too Short	Г	Mislabe	-		Power Loss/	_	Other					
		Inspection	n Strip in	Tube		Drawing		Misrea		<u></u>	<b>-</b>				
		Marks/Ch	atter			Drill Holes	$\Box$	Off-set							
		Turning S	equence			Finish		Out of	Calibration		·				
	Wave/Twist in Tube			e	Fit/Function	$\prod$	Out of Sequence								

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DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	D3161	REV. A
DATE 02	2.04.24	TITLE HINGE	SCALE NTS
 Α	02.04.24	NEW ISHE	
ALH	本 04.02.27	ADDED 103161-5	
AZ 11	14-04.06.30	100 03161-7 203161-9	



P/N	LENGTH 'L'	DESCRIPTION
D3161-1	13.5"	HINGE (REPLACES MS 20257-3-13.5 ON DZ183)
D3161-3	15.0"	HINGE (REPLACES MS 20257-3-150 ON D2950-041)
D3161-5	9.9"	HINGE
03161-7-	14.9"	HINGE
03161-9	17.9"	163094 pl 1304-18
k		
1		

## NOTES:

1 MAKE FROM MS20257-3-7200 HINGE

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